

Date: Friday, 12/09/2008 9:00:10 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BEARPAW KIT (EC 135)
 Job Number : 41995
 Estimate Number : 10536
 P.O. Number :
 This Issue : 12/09/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D135692011
 Drawing Number : D3049 REV A1
 Project Number : N/A
 Drawing Revision : A1
 First Issue : 12/09/2008 Type : MACHINED PARTS
 Material :
 Previous Run : 38555 Due Date : 30/10/2008 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : JLD 08.9.12
 Comment : Est Rev:C 04.02.17 Blank size changed, Tolerance added Step
 3 KJ/JLM
 Est Rev:D 08-04-16 Added Step 2 JLM Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JLD 08.10.01



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
 DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D135-692-011 CHG002

08/10/06

2.0 MFG ENGINEERING MFG ENGINEERING



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
 MFG ENGINEERING
 Program Batch Number

JLD 08.09.19

3.0 MUHMWB10 UHMW 1" Black



Comment: Qty: 5.6280 sf(s)/Unit Total: 22.5120 sf(s)
 blank: 16.00" x 23.50" x 1.00" thick (+0.030/-0.000)
 per DSK086-9
 Material: Black UHMW 1"(MUHMWB10)
 Batch: 11107067 X 6

M109497

X 6

(mat is not in computer)
 For M109497

M108013

X 2

08/10/03

B.A

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
 HAAS CNC VERTICAL MACHINING #1
 Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1

08/10/05

B.A

08/10/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/09/2008 9:00:10 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (EC 135)

Job Number: 41995

Part Number: D135692011

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Deburr

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
INSPECT PARTS AS THEY COME OFF MACHINE

26 08 / 10 / 05

6.0

QC8

SECOND CHECK



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
SECOND CHECK

28 08 / 10 / 05

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PACKAGING RESOURCE #1
Pick Packing Kit

8.0

D2182B

Rubber Cushion



Comment: Qty.: 2.0000 f(s)/Unit Total : 8.0000 f(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2182B060 (6.00")

Rubber Cushion

B39986

26

9.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 D2274

Radius Block

B35205 20x

B38173 12x

26

10.0

D2519

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2519

Clamp

B34306

26 8/10/06 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/09/2008 9:00:10 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (EC 135)

Job Number: 41995

Part Number: D135692011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

8 D2529

Washer

Batch

B 38188

12.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

8 AN4-15A

Bolt

Batch

M128077

13.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

8 AN960JD416

Washer

Batch

M108827

14.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

8 MS21042L4

Nut (or -4)

Batch

M108145

15.0

QS100M24S

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

2 D3049-1(ref)

Bearpaw

Batch

41975

4 QS100M24S

Clamp

M106755

3X

M107746

M1093893X

1 Paperwork package from Step 2(ref)

10X

EC 8/10/6 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/09/2008 9:00:10 AM

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Job Number: 41995

Part Number: D135692011

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
INSPECT 100% KITS FOR COMPLETENESS

JS 08/10/06 (x4)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D135-692-011

Location: _____

PPP Rev: _____

Rev C

JS 08/10/06 (x4)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
FINAL INSPECTION/W/O RELEASE

08/10/08

Job Completion



MF 08-10-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41995
Description: Bearpaw		Part Number: D3049-1
Inspection Dwg: D3049	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø0.260	+0.005/-0.000	.260				
B	0.93	+/-0.030	.93				
C	0.40	+0.030/-0.000	.420				
D	2.00	+/-0.030	2.00				
E	10.250	+/-0.010	10.250				
F	4.540	+/-0.030	4.545				
G	5.88	+/-0.030	5.88				
H	0.38	+/-0.030	.38				
I	11.50	+/-0.030	11.50				
J	0.07 x 45°	+0.030/-0.010	.07 x 45°				
K	0.44 - 0.47	+/-0.000	.455				
L	R0.25	+/-0.030	R.25				
M	0.38	+/-0.010	.38				
N	0.95	+0.030/-0.010	.96				
O	0.69	+/-0.030	.710				
P	0.20	+/-0.030	.205				
Q	23.00	+/-0.030	23.0				
R	0.25 x 45°	+/-0.030	.25 x 45°				

Measured by: AD	Audited by: LB	Prototype Approval:	N/A
Date: 08/10/04	Date: 08/10/04	Date:	N/A

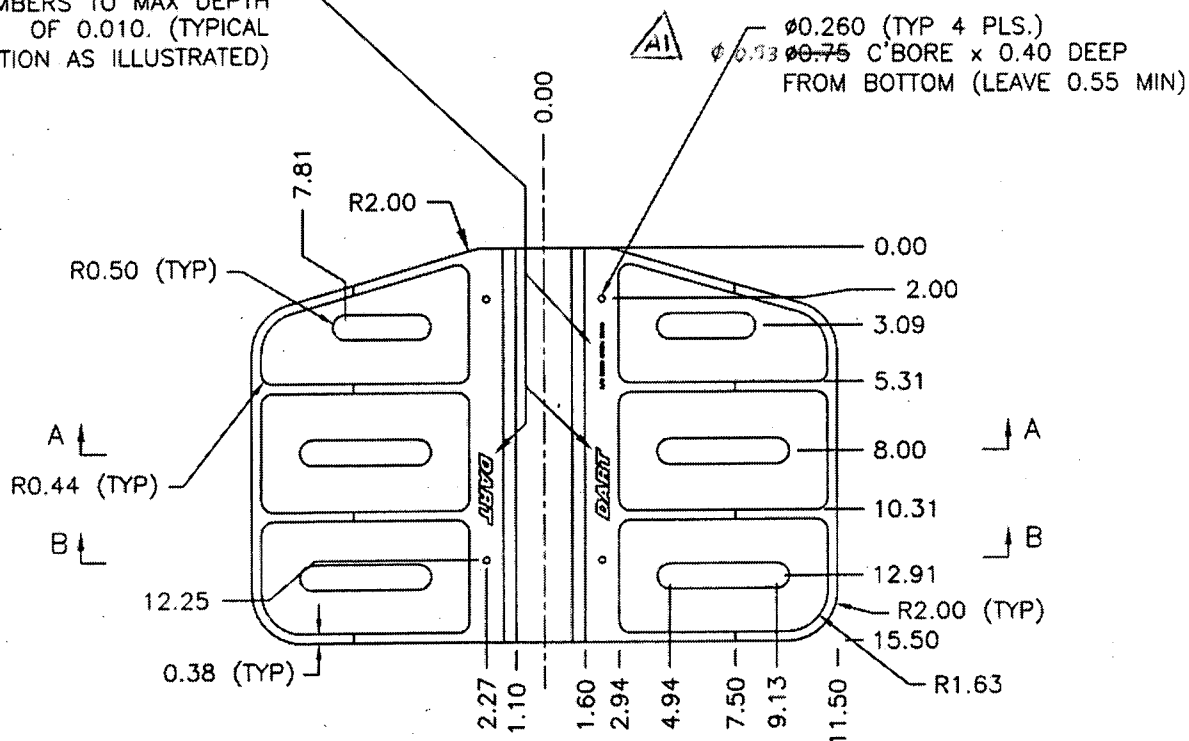
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D135-692-011	KJ/RF	
B	08.05.06	Dimension I revised	KJ/DD	



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:1
A	01.10.18	NEW ISSUE	
AI	03.01.13	Ø0.93 WAS Ø0.75	

RELEASED
01.10.24

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)

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WITHOUT NOTICE
WORK ORDER
NO. 41995

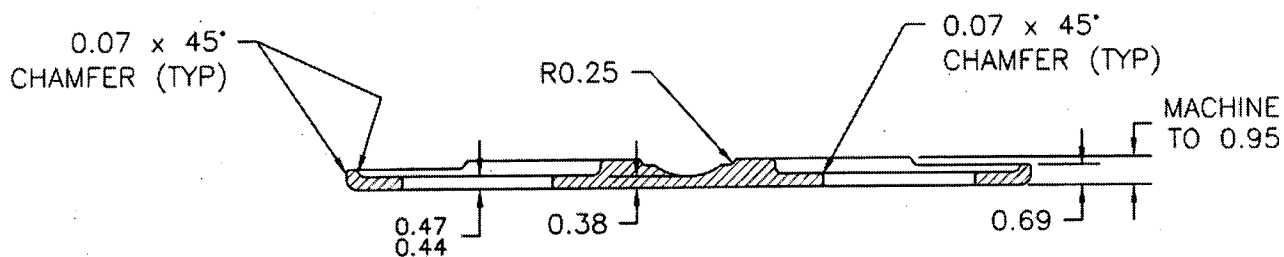
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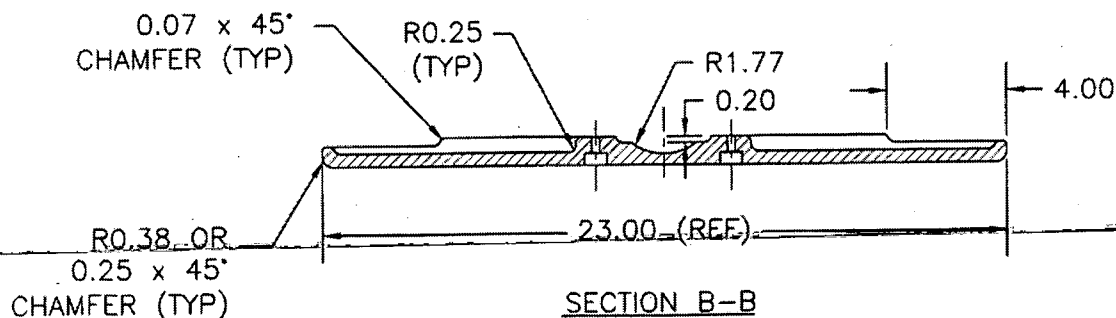


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED
01.10.24 #



SECTION A-A



SECTION B-B

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NO. 41995

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